

S205619



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2622-120C
Job Sheet 196288



Part No: D2622-120C

Job Qty: 120 pcs

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/23/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	120 pcs	7/23/19	7/23/19	0.00	0.00	Purchasing - 1		At 19/06/19
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	120 pcs	7/23/19	7/23/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Container No: S205619



Part: D2622 - 120C

Job No: 196288

Serial No/Batch: S205619

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/14/19

Plex 6/13/19 7:51 AM dart.lavoie.chanta

					B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	At 19/08/14
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 18	120 pcs	7/23/19	0.00 0.00	QC 18 - 12		
				QC 18 - 14		
				QC 18 - 22		
				QC 18 - 25		
				QC 18 - 48		
				QC 18 - 58		DAS
				QC 18 - 61		61
				QC 18 - 9		9-89
130 Packaging 3-1 - Stock - B4B	120 pcs	7/23/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 -		

				B4B	
				Packaging 3 - 17 - B4B	SLA
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	120 pcs	7/23/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21
				QC 21 - SA - 53	AUG 15 2019

Part Op **100** - Purchasing - Issue P/O: _____ a) Extrude as per Dwg D2622 Rev. C f) Order at 120" longg) Bon L
 Descriptions: Canada Inc.

110 - Receive & Inspect for Damage & Mat'l Certs - Ensure material certification is attached

120 - QC18 In-Coming Inspection Material - Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester

130 - Identify as per dwg & Stock Location: _____ LOCATION : HALL

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120CP	Extrusion	120 pcs (1 ea)	100-Purchasing	S205616

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2622-120CP	120	0	0

Part Specifications

Specifications could not be found.

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Chantal Lavoie

From: Desbiens, Marc <mdesbien@amcastle.com>
Sent: Wednesday, June 12, 2019 4:55 PM
To: Chantal Lavoie
Subject: RE: quote

Good afternoon Chantal,

price an delivery on mat'l.

7075t6 plate 1" x 8" x 12 ft \$ 52.95 FT 3 weeks

7075t6 plate 1.750" x 3" x 12 ft offer 1 or 2 pcs 95" Long \$ 43.45 Ft 3 weeks

Thanks

Marc Desbiens
Inside sales representative
Castle Metals, Montreal, QC
Direct line 514-795-8176
1-800-806-6660 ext 52226
Fax # 1-855-892-6370

Customized Supply Chain Solutions for Your Metal Needs

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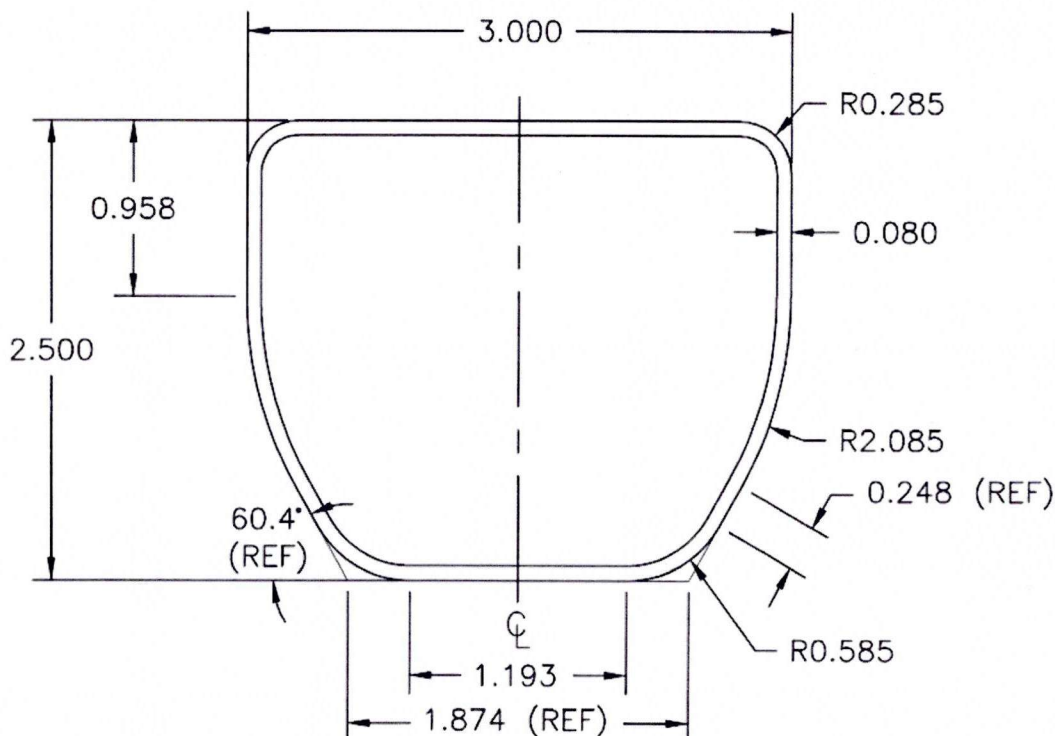
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DESIGN KE	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	UP 02.10.04	ADD 'REV-A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043711



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB043711

PO Date: 6/13/19

Due Date: 7/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
JUN 17 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184964	D2622-120CP		Extrusion : EXTRUDE AS PER DWG D2622-120 REV. C DIE # DAA- 897123 LENGHT 120" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Firmed	-	7/19/19	120 pcs	0 pcs	120 pcs	\$25.377916/pcs	\$3,045.35
											Grand Total: \$3,045.35	

CL

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043711



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU

07-29-19

PACKING LIST NUMBER / N° DE BODEREAU

043875

SALES ORDER NUMBER / N° DE COM

136810

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT	ORDER DATE / DE LA COM	CUSTOMER PO NUMBER / CLIENT PO Nombre	LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
46024	06/17/19	POHB043711 	PIC	13-02	042		G.ATTENBOROU
		BILL OF LADING NUMBER / NO. DE CONNAISSEMENT	JOB / FICHIER			FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP. SERVICE CLIENTELE
		043875		CARRIER / TRANSPORTEUR		G.ATTENBOROU	D1K
				CANUS			

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,104	LB		DAA-897123-2	6061 T6		3	1,279	1,213	LB	
	501	KG		D2622-120CP	120.0000 IN			580	550	KG	
Y	121	PC			Cut (+): 0.1180 Cut (-): 0.0000	Min: -10 % Max: 10 %			134	PC	

						922575 / 501800	1	467	445		49 PC
						922575 / 501801	1	467	445		49 PC
						922575 / 501802	1	344	322		36 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

Page 1 of 1

3	1,279	1,213	LB
	580	550	KG
		134	PC
TOTALS			

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CUSTOMEI

DATE OF DELIVERY

DRIVER



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
07/29/2019	5541289	136810	1
Cust PO	B/L No	Lot	Date
POHB043711	043875	922575	07/29/19

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10FT MILL 6061 T6	D2622-120CP
Gross Weight	1,279 LBS		
Net Qty	1,213 LBS		134 PCS
			3 PKGS
Specification			Die Desc
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
299.3 / 43.4	271.1 / 39.3	13.1	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.60	0.32	0.20	0.09	0.86	0.05	0.09	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-1206
 DATE: 19/08/14

PO / BATCH NO.: POHB043711/
5205619

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 134x
 QUANTITY INSPECTED: 134x
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.080"
 THICKNESS RECEIVED: 0.080"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☐	
CORRECT FINISH	☒ Y ☐ N	
CORROSION	Y ☒ N ☐	
CORRECT GRAIN DIRECTION	☒ Y ☐ N	
CORRECT MATERIAL PER M-DRAWING	☒ Y ☐ N	AMS QQ-A-200/B
CORRECT THICKNESS	☒ Y ☐ N	
PHOTO REQUIRED	Y ☒ N ☐	
CORRECT REF # TO LINK CERT	☒ Y ☐ N	HT: 922575
CORRECT MATERIAL IDENTIFICATION	☒ Y ☐ N	
CORRECT M# ON THE MATERIAL	☒ Y ☐ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N ☐	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N ☐	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>61</u> DATE: <u>AUG 14 2019</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in